

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025504**Date Inspected:** 24-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. An Qing Xing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Chang xing Island in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly**SMAW Process:**

This QA Inspector observed ZPMC qualified welding personnel identified as 216086 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13 East (CE). Joint identified as SEG3011C-246, 247. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 581021 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13 East (CE). Joint identified as SEG3011-009, 010. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2113-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 581021 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13 East (CE). Joint identified as SEG3011-011, 012. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112-FCM-1.

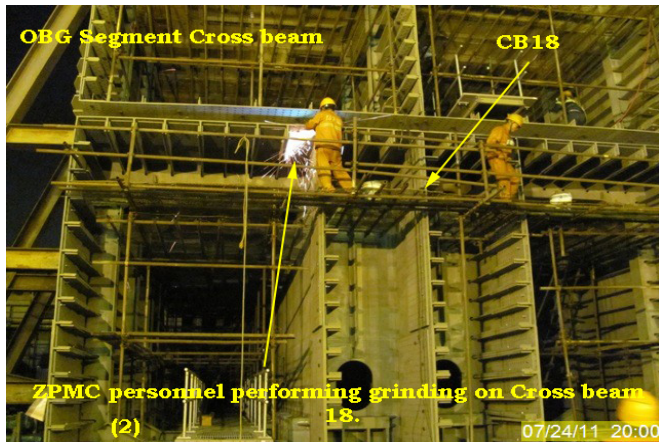
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This QA Inspector observed ZPMC qualified welding personnel identified as 581021 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13 East (CE). Joint identified as SEG3011-013, 014. ZPMC CWI Identified as An Qing Xing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2113-FCM-1.

This QA Inspector observed that ZPMC personnel were identified during grinding on OBG Segment Cross beam 18. The grinding at various Location on top plate stiffener. For more information see below attached picture number 2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer